

Date: Monday, 7/31/2006 12:50:04 PM  
User: Kim Johnston

## **Process Sheet**

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 350/212/130 BASKET LID
<b>Job Number</b>	: 28036B	<b>Part Number</b>	: D2512
<b>Estimate Number</b>	: 10193	<b>Drawing Number</b>	: D2512 REV D2
<b>P.O. Number</b>	: N/A	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 7/31/2006	<b>Drawing Revision</b>	: D2
<b>Prsht Rev.</b>	: NC	<b>Material</b>	: N/A
<b>First Issue</b>	: N/A	<b>Due Date</b>	: 8/7/2006
<b>Previous Run</b>	: 27997B	<b>Qty:</b>	1
<b>Written By</b>	: <u>HJ</u>	<b>Um:</b>	Each
<b>Checked &amp; Approved By</b>	: <u>HJ</u> 06.07.31		
<b>Comment</b>	: Rev Est:M 08.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W 
		
	Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
	Pick: 3/4"x3/4" 304/316 SS tube .063" wall Batch: <u>M101509-51 M101561</u>	 06-08-10 
2.0	D31663	Basket Hoop 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick: Qty Part Number Description Batch 1 D3166-3 Basket Hoop <u>B23095</u>	 06-08-15 
3.0	D2506	Placard 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick: Qty Part Number Description Batch 1 D2506 Label Plate <u>B26631-2</u>	 06-08-05 
4.0	D23271	Spacer Bushing 
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick: Qty Part Number Description Batch 2 D2327-1 Bushing <u>B26742</u>	 06-08-15 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 7/31/2006 12:50:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28036B

Part Number: D2512

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D22321	Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2232-1	Hinge plate	B25233

PD

06-08-22

(1)

6.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2581	Mounting Bracket	B27524-1 B27587-1

PD

06-08-22

(1)

7.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number	Description	Batch
18 sf	M304EX0.75-16F Expanded Metal	M1017D7

PD

06-08-22

(1)

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

9.0	QC9/6	DDIMENSIONAL & WELDING INSPECTION
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Comment: DDIMENSIONAL & WELDING INSPECTION

06-08-22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: 

Date: 06/08/127

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Monday, 7/31/2006 12:50:04 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28036B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/08/23

①

11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M10626

9. m 06-08-24

②

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf. 06/08/24

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF - 06/08/24

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.25

Job Completion



U 06.08.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

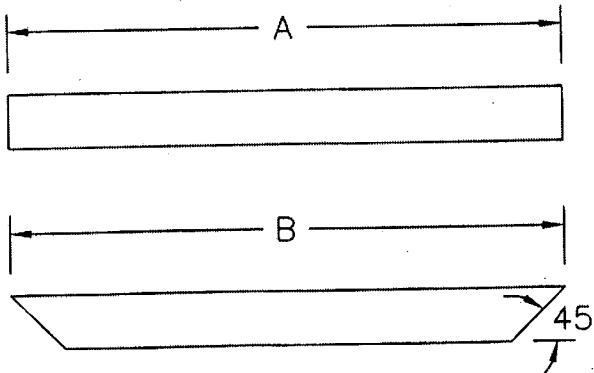
DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS

**RELEASED**  
01.04.27 *CP*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	<del>CP</del> 03.01.20	ADD D2012-117 FOR D130-701-041
D2	<del>CP</del> 04.09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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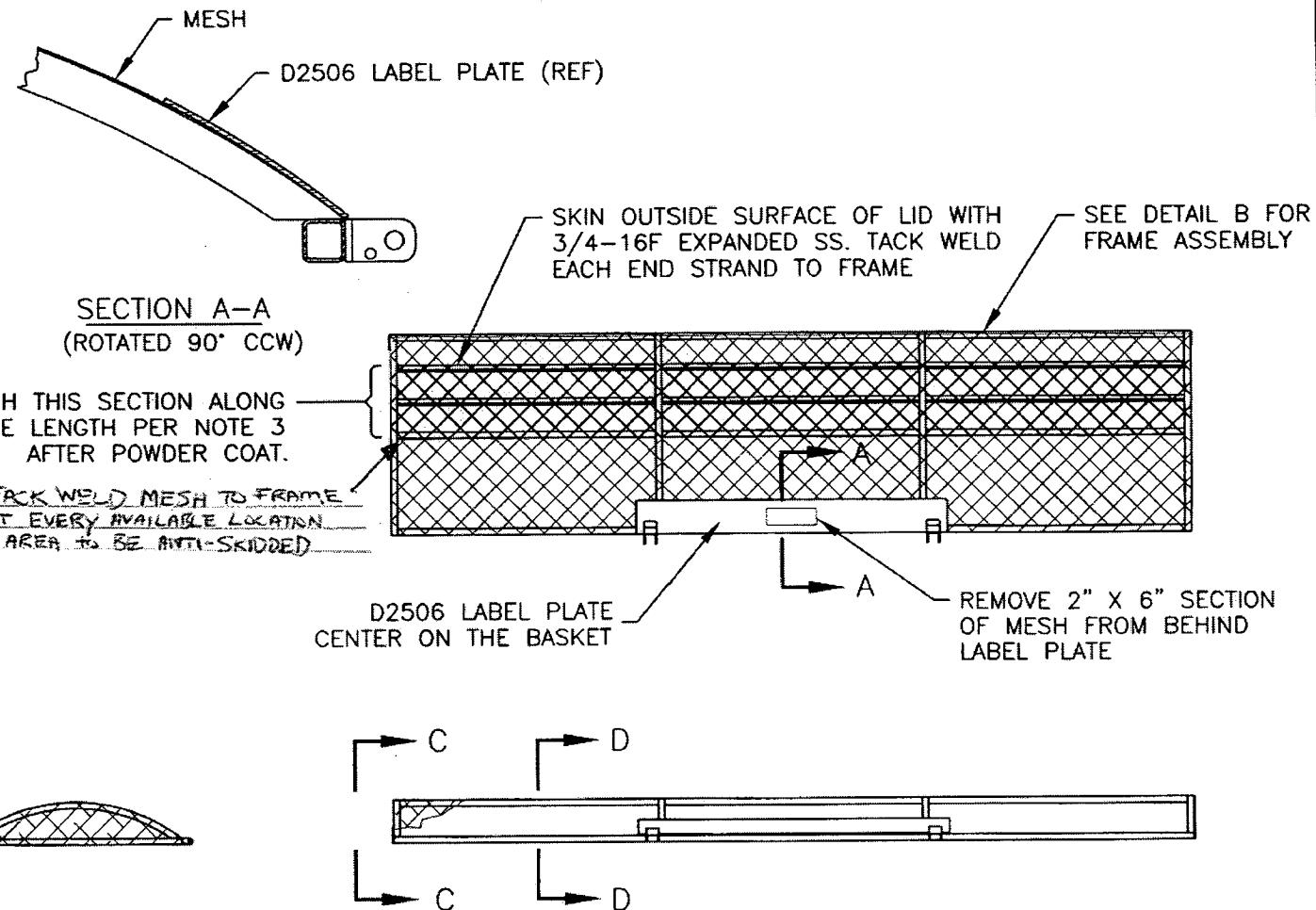
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D2



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

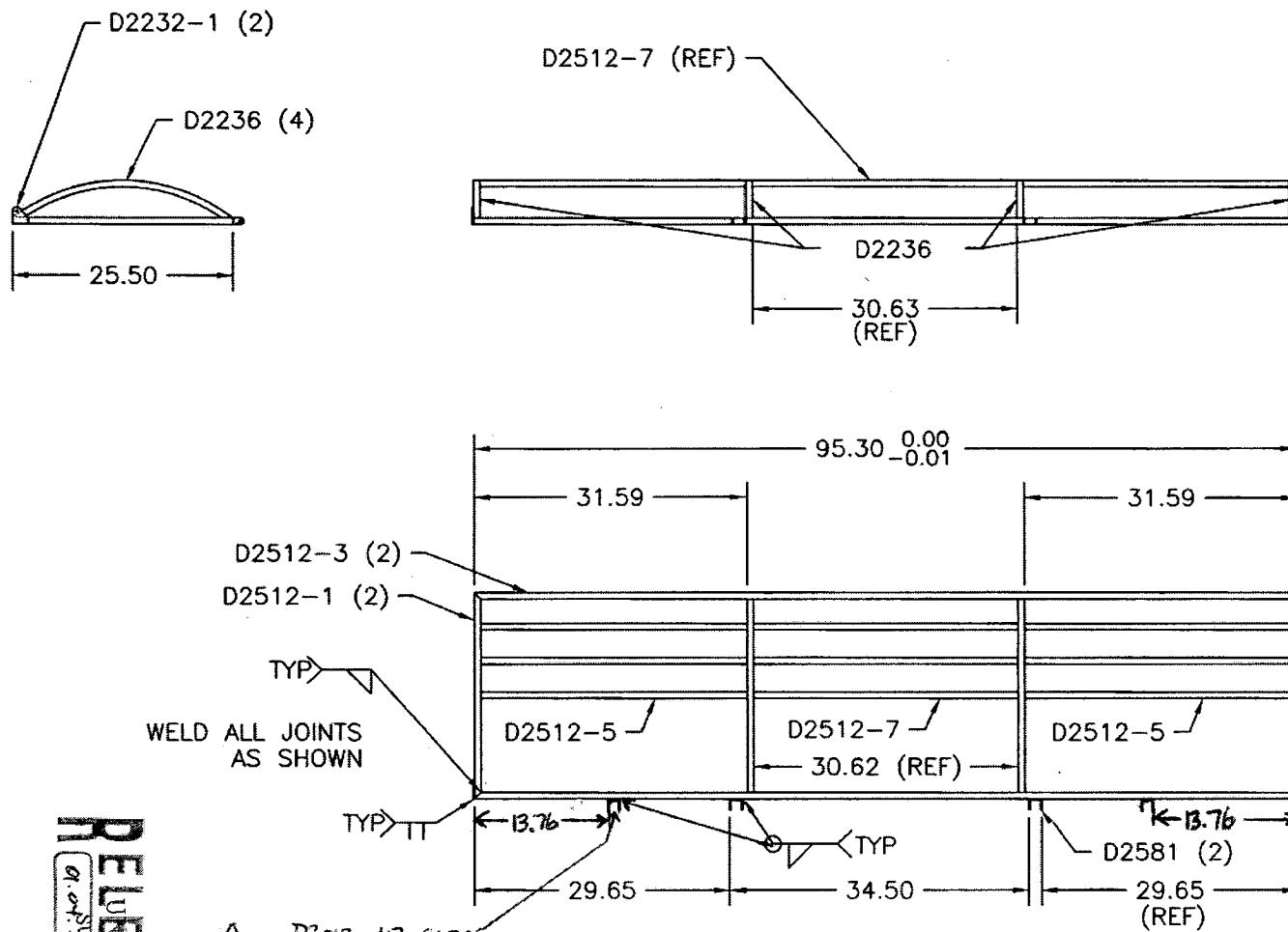
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DATE 01.04.19	DRAWING NO. D2512	REV. D
TITLE BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4	SCALE 1:20

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CHECKED <i>J</i>	APPROVED <i>J</i>	DRAWING NO. D2512
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)	REV. D SHEET 3 OF 4 SCALE 1:20

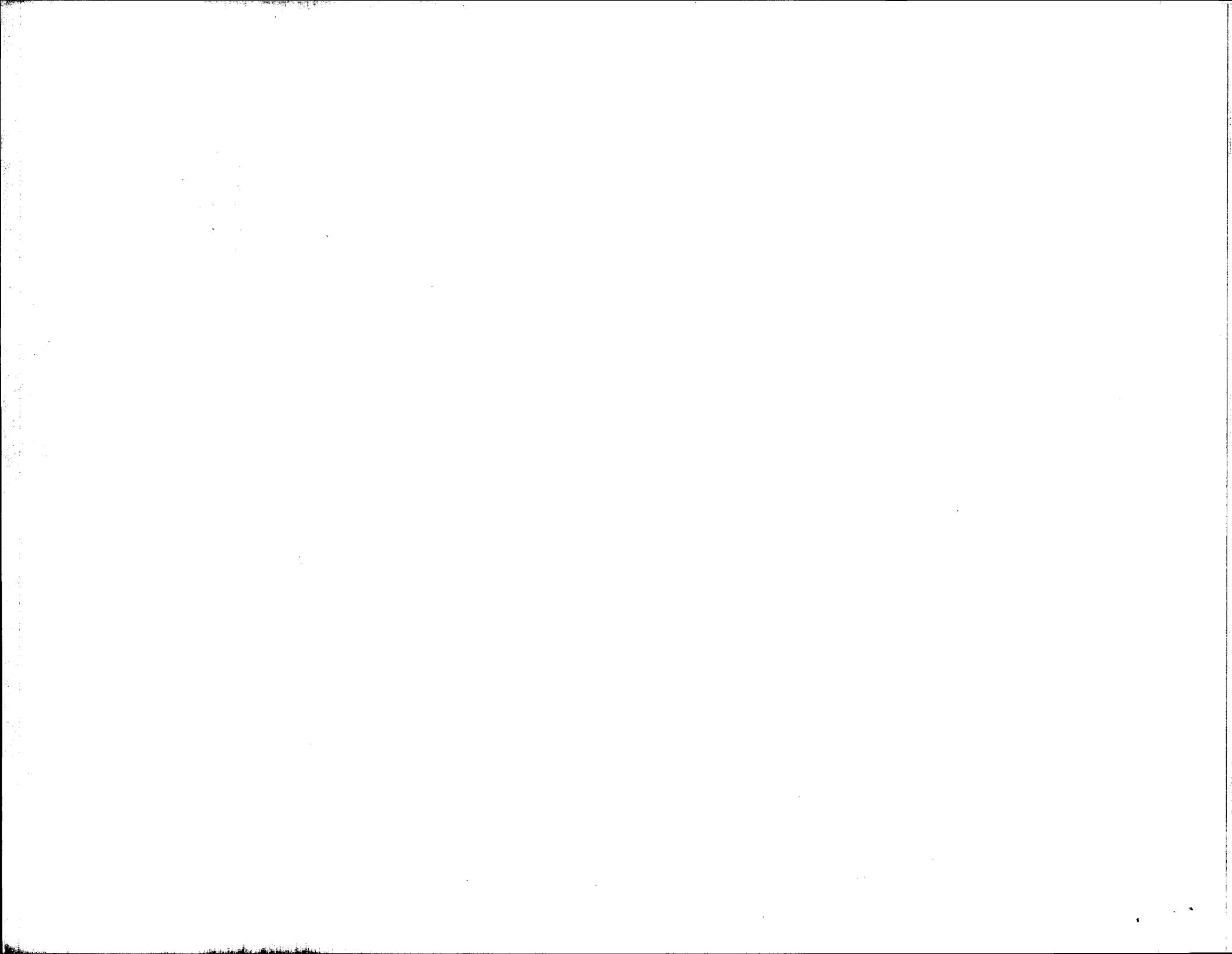


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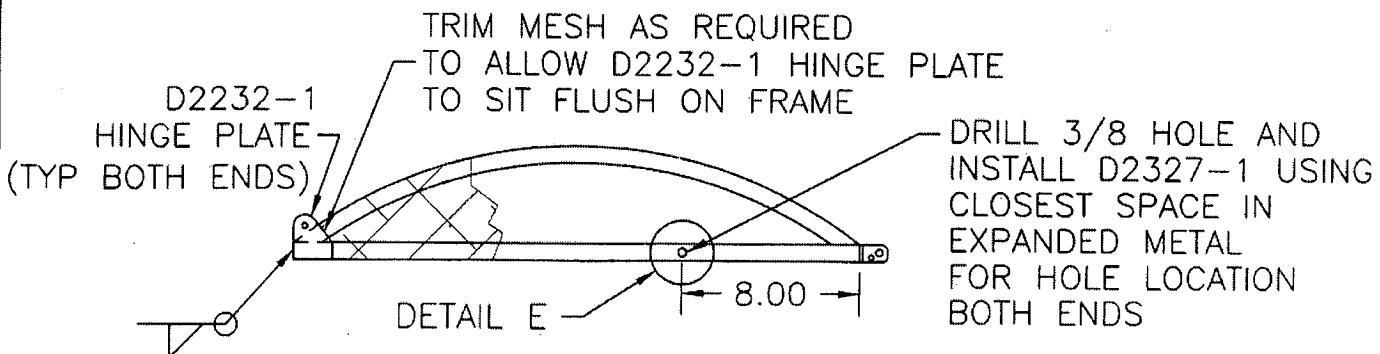
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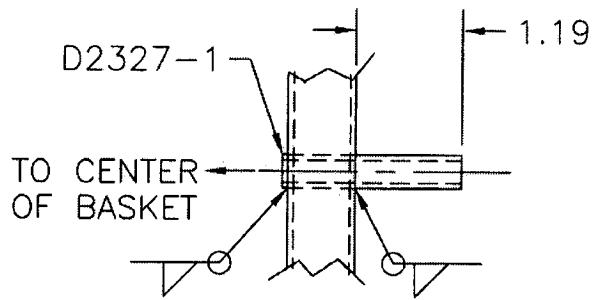


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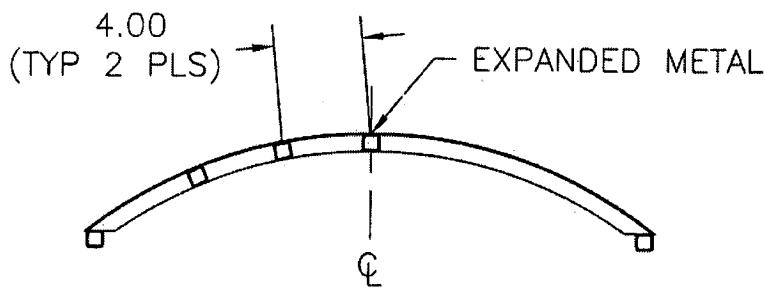
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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